

75251

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

24

24

Customer:

Run Start *NR1*

Date:

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D2858	BAND SAW	0.00							
100	Memo	0.00							
Jearpa Bandsaw	Cut blanks 5.850								
	" Note: 1 Blank Makes 3 Parts								
HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1	0.00							
110	' Memo	0.00							
FOLIO REV:	1-Machine per folio FA941								
DWG REV:	FOLIO REV: 1A								
QC2- Inspect parts off machine FAI/FAIB	DWG REV: C								
	2-Deburr any rough edges								
Quality Control	QC	0.00							
120	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75251

75251

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October-19-11 1:35:40 PM

Item ID: D2858-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 19/10/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>an Ld/11/03</i> <i>10/11/03</i>			<u>17</u>			
--	---	--------------	--	--	--	-----------	--	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>17</u>	<u>BR 11-11-03</u>		
---	---	--------------	--	--	--	-----------	--------------------	--	--

150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							
---	--	--------------	--	--	--	--	--	--	--

START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____

M118439 3200F 7=40 8-10

17X4 m-11/11/08

W/O:		WORK ORDER CHANGES					
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Work Order ID 75251

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75251

Page 3

Item ID: D2858-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 19/10/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				17 x	f	24 u/a/08	
Quality Control						COUNT			
170	Identify as per dwg & Stock Location 0267	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

17 x f 24 u/a/08
COUNT

Paul/11/8 (12)

11/11/8 *[Signature]*

mf
11-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October-19-11 1:35:44 PM

Page 1

Work Order ID: 75251

75251

Parent Item: D2858-2

D2858-2

Parent Item Name: Hinge Bracket

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	9.1020	0.163	4.117895			

M6061T6B1 500X01 250

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

9.102

118071

0.112

→118400

8.99

2' on 10/10/30

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	7525-1
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.171	/		JLM06	
Ø0.400	+0.005/-0.000	.402	/		"	
R0.125	+/-0.010	.125	/		"	
0.328	+/-0.010	.328	/			
0.820	+/-0.005	.820	/			
1.476	+/-0.010	1.477	/			
0.342	+/-0.010	.342	/			
0.875	+/-0.010	.875	/			
1.56	+/-0.030	1.560	/			
0.147	+/-0.010	.150	/			
0.717	+/-0.010	.715	/			
0.697	+/-0.010	.697	/			
0.229	+/-0.010	.232	/			
R0.125	+/-0.010	.125	/			
R0.063	+/-0.010	.063	/			
0.063	+/-0.010	.063	/			
0.126	+/-0.010	.126	/			
0.630	+/-0.010	.630	/			
R0.354	+/-0.010	.354	/			
0.965	+/-0.010	.966	/			
Ø0.166	+0.005/-0.000	.168	/			

Measured by:	<i>BL</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11/11/07	Date:	11/11/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	<i>[Signature]</i>

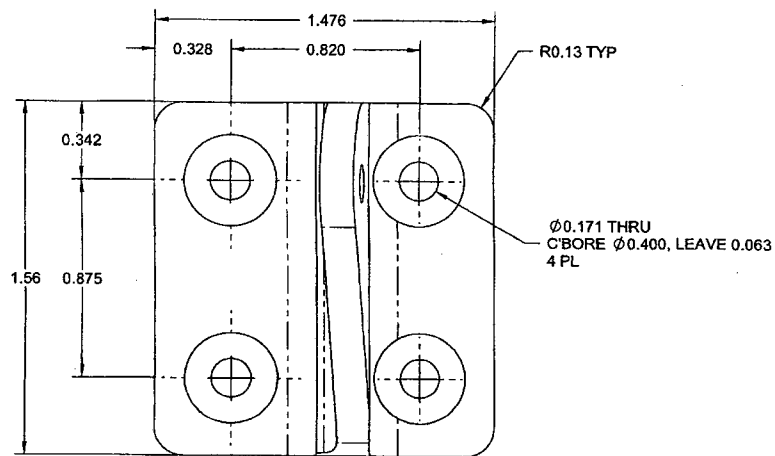
W/O:		WORK ORDER CHANGES						
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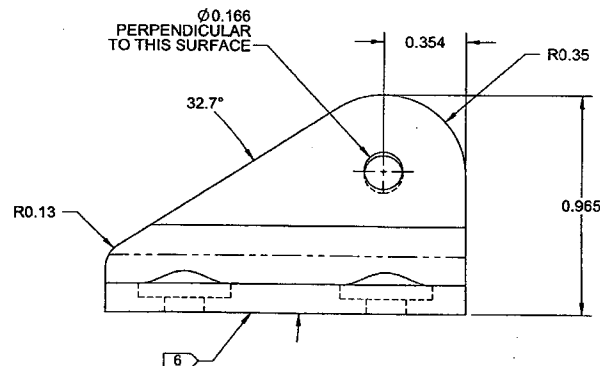
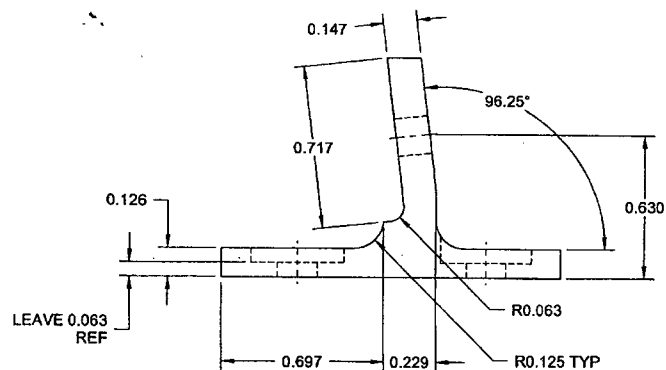
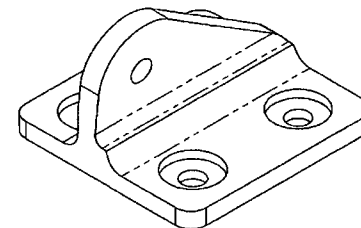
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75251 M.C.J
1110119



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD. REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1, A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	ap		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2858**
TITLE **HINGE BRACKET**
REV. C
SHEET 1 OF 2
SCALE
NTS

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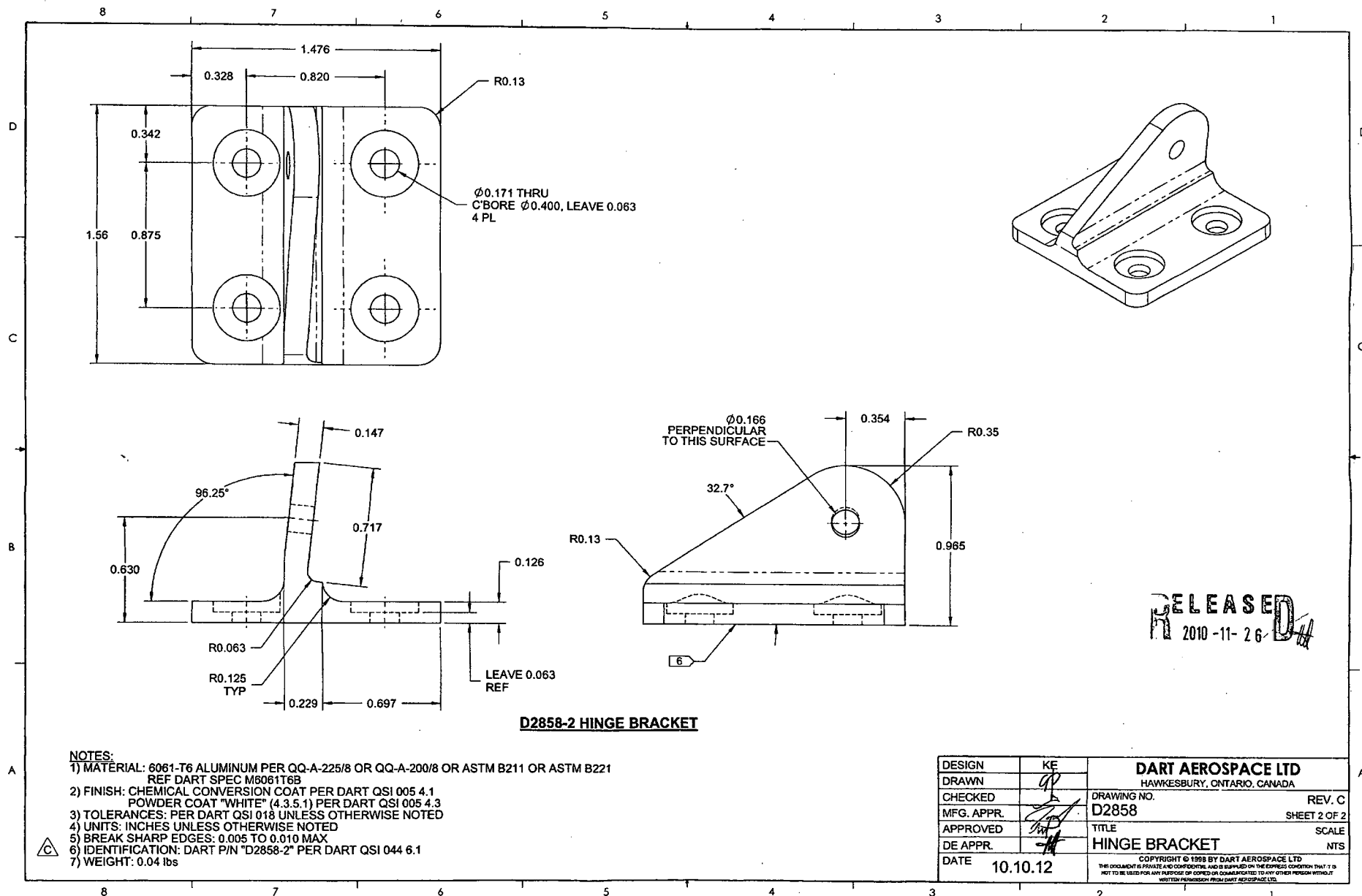
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